

Date: Wednesday, 10/31/2007 3:26:04 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	JACK SADDLE
Job Number	35471		
Estimate Number	11177		
P.O. Number	N/A	Part Number	D2281
This Issue	10/31/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2281 REV G
First Issue	N/A	Project Number	N/A
Previous Run	34181	Drawing Revision	G
Written By		Material	N/A
Checked & Approved By	<i>[Signature]</i> -07.11.01	Due Date	11/30/2007
Comment	Est Rev: A Removed from 9 Digit 05-12-02 JLM Est: rev B 06.07.17 waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304S14GA	304SS .080
	Comment: Qty.: 0.1313 sf(s)/Unit Total : 13.1250 sf(s) 304SS .080 batch: 10S112	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D2281 Dwg Rev: G Prog Rev: G	 <i>RB 07-11-1</i> <i>(98)</i>
	2-Deburr if necessary	<i>RB 07-11-1</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <i>RB 07-11-1</i>
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
		 <i>QSP019</i> <i>cancel</i>
	Comment: SECOND CHECK	<i>as Alu/15</i> <i>(198)</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 <i>n/a</i> <i>Alu/15</i> <i>(22)</i>
	Comment: Deburr	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/11/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 35471		Part Number: D2281
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC 	NC BRAKE 
Comment: NC BRAKE Form as per D2281 using D2281-T2		SB 07/11/08 98
7.0	QC5 	INSPECT WORK TO CURRENT STEP QSP019 C 07/11/08 X98 counts
Comment: INSPECT WORK TO CURRENT STEP		
8.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 		W 07.11.08
9.0	QC21 	FINAL INSPECTION/W/O RELEASE  07/11/08
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		U 07.11.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35471
Description: Jack Saddle	Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

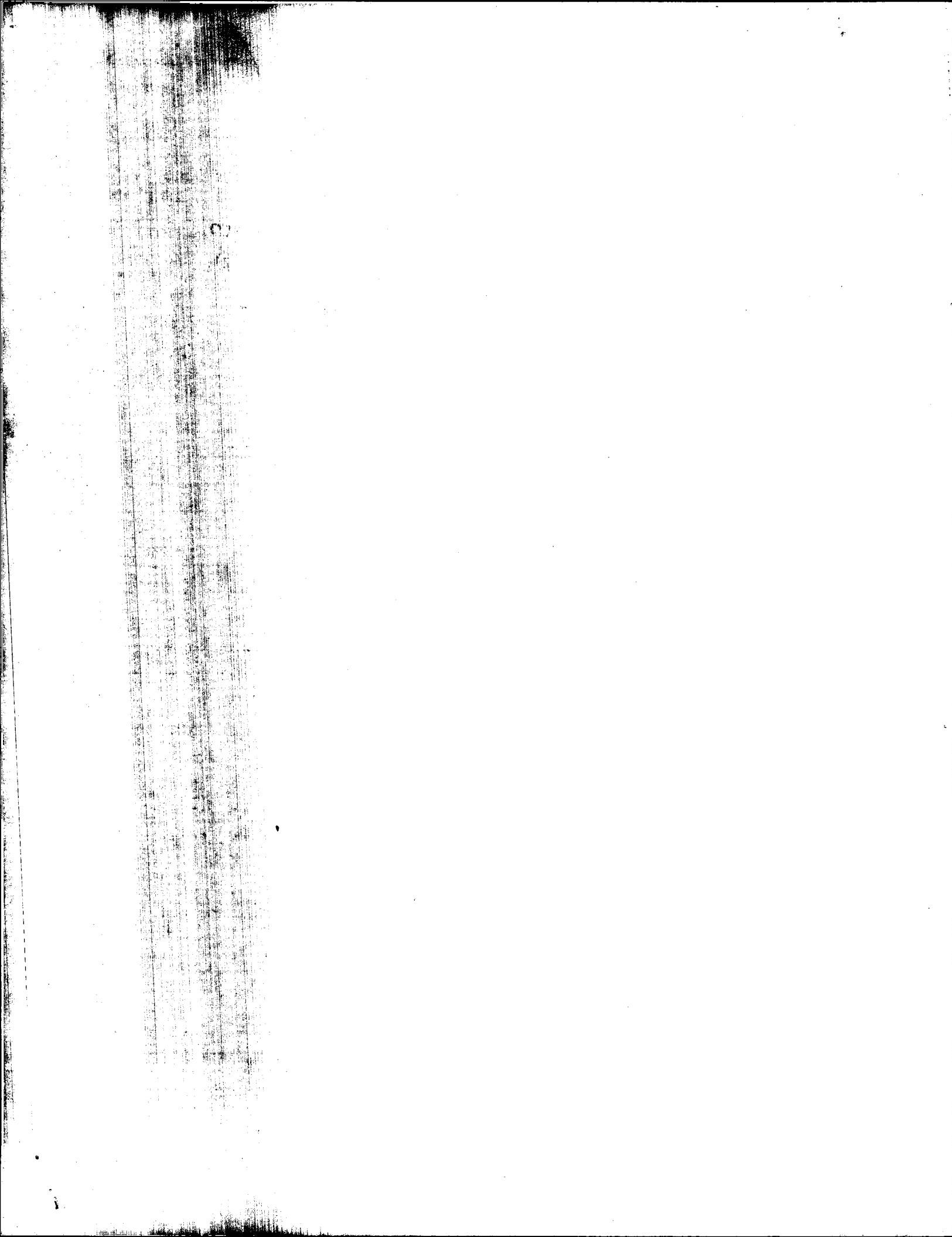
X First Article Prototype

Measured by:	H3
Date:	07-11-1

Audited by: *[Signature]*
Date: *7/11/05*

Prototype Approval:	N/A
Date:	N/A

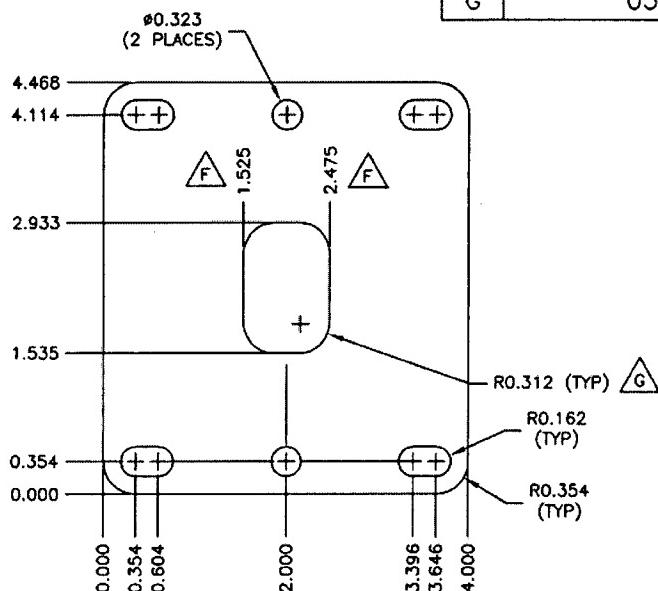
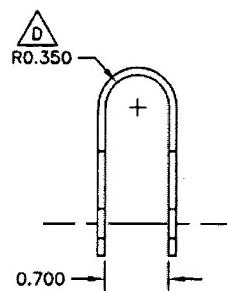
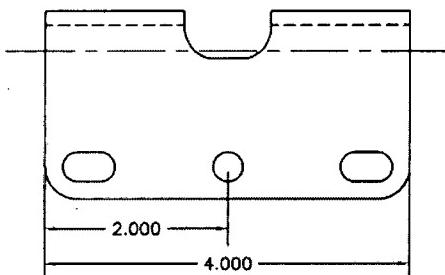
Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	JM



DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>MMS</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
[Signature]
 05/08/11

FLAT LAYOUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *35471*

D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

